

Work Order ID 74187

Tuesday, September 27, 2011 9:04:46 AM



Page 1

Item ID: D3167-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw

Start Date: 9/27/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 10/13/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3167

Rev A1

120

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as per File D3167-1_BLANK

Blank

4

130

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Note: (2) Bearpaw for (1) Kit
1-Inspect material for defects or damage prior to machining
2-Machine as per Folio FA285 and Dwg D3167
3-Deburr

amt 11/12/08

4

0

140

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

amt 11/12/08

4

0

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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Page 2

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Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

12 11.12.9

4 0

151

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

PM 74186

10/12/09 (4)

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/12/13

111209

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Picklist Print

Tuesday, September 27, 2011 9:04:43 AM

Page 1

Work Order ID: 74187



Parent Item: D3167-1



Parent Item Name: Bearpaw

Start Date: 9/27/2011

Required Date: 10/13/2011

Start Qty: 4.00

Required Qty: 4.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MUHMWB10

Purchased

No

120

sf

623.6200

3.6

14.4



B11-9-29

UHMW 1" Black

Location

Loc Qty

Loc Code

MAT018

383.62

117321

76.6

117738

124.3

117819

99.3

118257

83.42

ST

240

118814

240

118814

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DART AEROSPACE LTD		Work Order:	79107
Description: Bearpaw		Part Number:	D3167-1
Inspection Dwg: D3167 Rev: A1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.06 x 45°	+0.030/-0.010	0.050 x 45°	—		Ucon ML-66	
B	5.80	+/-0.030	5.800	—		"	
C	0.25 x 45°	+/-0.030	0.265 x 45°	—		"	
D	R0.25	+/-0.030	R.250	—		R-6	
E	0.200	+/-0.030	.193	—		Ucon ML-66	
F	0.250	+/-0.010	.246	—		"	
G	0.625	+/-0.030	.630	—		"	
H	0.375	+/-0.010	.379	—		"	
I	0.950	+0.030/-0.010	.943	—		"	
J	3.21	+/-0.030	3.210	—		"	
K	19.00	+/-0.030	19.000	—		"	
L	Ø0.260	+0.005/-0.000	Ø.260	—		"	
M	Ø0.93	+/-0.030	Ø.928	—		"	
N	0.30	+0.030/-0.000	.308	—		"	
O	0.375	+/-0.030	.375	—		"	
P	7.23	+/-0.030	7.230	—		"	
Q	4.54	+/-0.010	4.540	—		"	
R	2.00	+/-0.030	2.000	—		"	
S	12.000	+/-0.010	12.000	—		"	
T	6.000	+/-0.010	6.000	—		"	
U	23.75	+/-0.030	23.750	—		"	

Measured by:	amf	Audited by:	TR	Prototype Approval:	N/A
Date:	11/12/08	Date:	11.12.8	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D130-700-011	KJ/RF	

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DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3167	REV. A SHEET 1 OF 2
DATE 02.10.08		TITLE BEARPAW	SCALE 1:6
A	02.10.08	NEW ISSUE	
AI	02.12.17	5.80 was 5.50 	

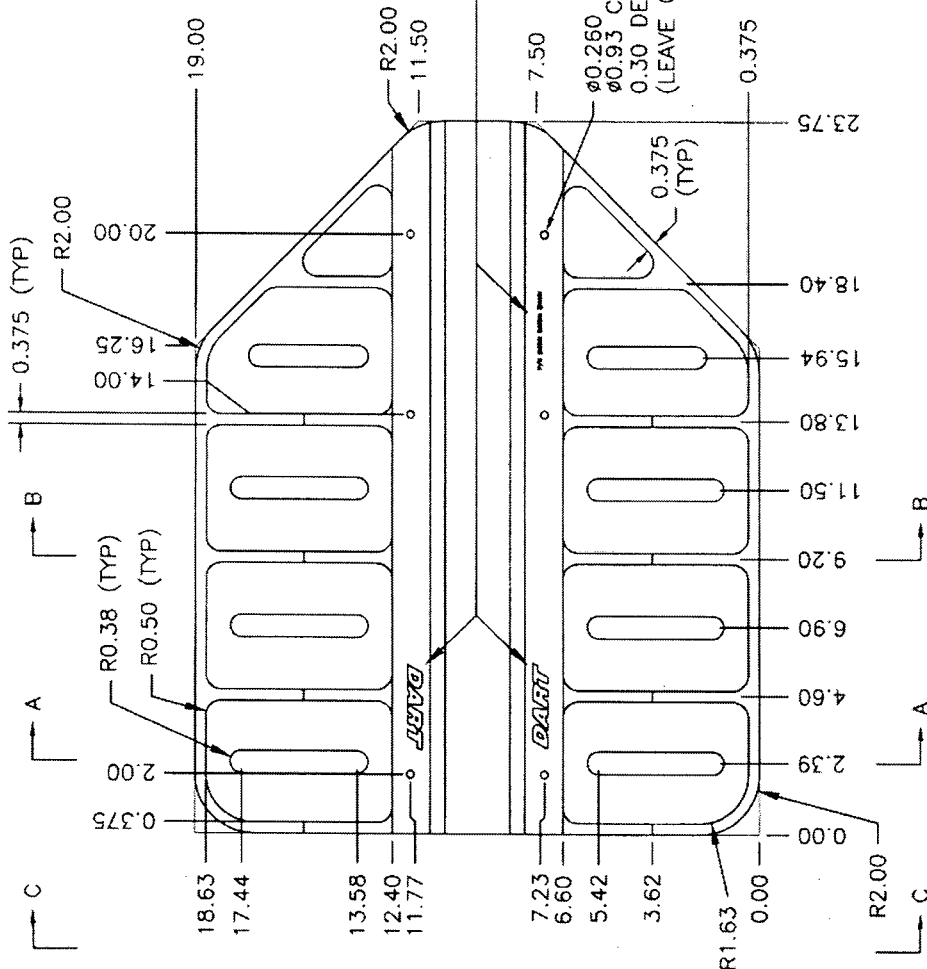
52-10-25

ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)

ø0.260 (TYP)
 ø0.93 C BORE
 0.30 DEEP FROM BOTTOM
 (LEAVE 0.650 MIN.)

18117079

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D3167-1

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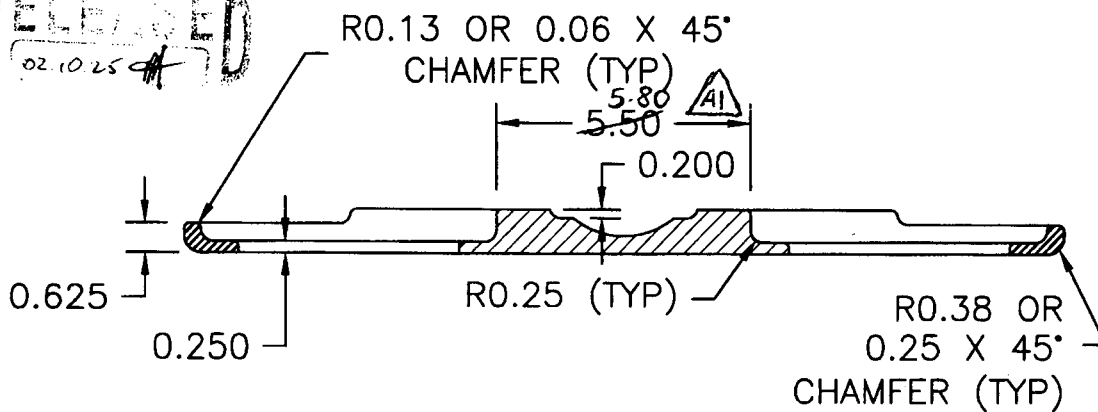
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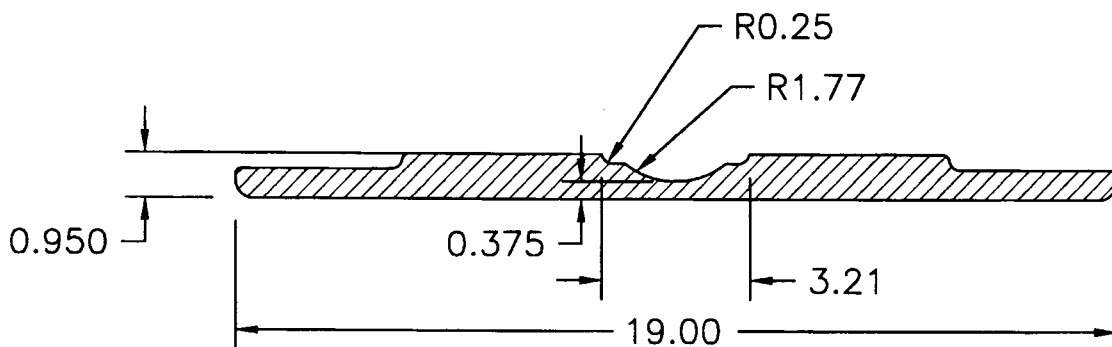


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CHECKED 	APPROVED 	DRAWING NO. D3167	REV. A SHEET 2 OF 2
DATE 02.10.08		TITLE BEARPAW	SCALE 1:4

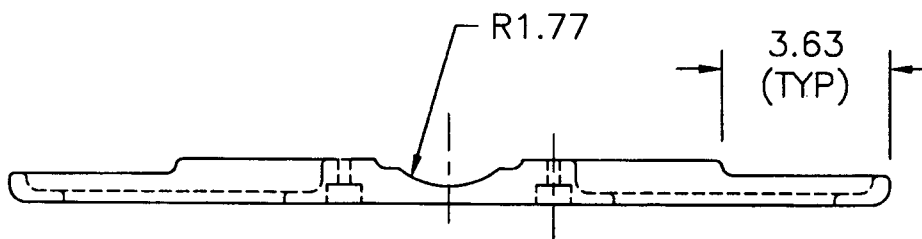
RELEASED
02.10.25



SECTION A-A



SECTION B-B



SECTION C-C

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